

Work Order ID 48670C

Friday, June 26, 2009 9:20:49 AM

Page 1

Item ID: D412-694-03

Accept

Revision ID: C1

Item Name: Door Assembly

Start Date: 7/15/2009 Start Qty: 1.00

Required Date: 8/3/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D412-694

Rev C1

100



DC

Document Control

✓ DOCUMENT CONTROL

0.00

Memo

Issue red decal labels for D412-694-03. CHG005

110



Small Fab

Small Fab

✓ COMPOSITE ASSEMBLY

0.00

Memo

D412-694-03 Drill Process □ 1- Drill pilot holes Ø(#30) using drill Jig D3144-T4 for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T5/-T6 as per Dwg D412-694 page 3. Note: Ensure slot is aligned wi

120



Small Fab

Small Fab

✓ COMPOSITE ASSEMBLY

0.00

Memo

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM). □ 2- Sand flush excess Hysol around the insert on both doors.

EA 934 A/R M110970
M112099

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Page 2

Item ID: D412-694-03

Accept

Revision ID: C1

Item Name: Door Assembly

Start Date: 7/15/2009 Start Qty: 1.00

Required Date: 8/3/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect that inserts are flush with the surface.

09/10/07

140

COMPOSITE ASSEMBLY

0.00



Small Fab

Memo

0.00

Small Fab

1. Apply Primer filler and reducer around the inserts on both doors. ☐ A/R

11045 Primer Filler

Batch: 1112704 ☐ A/R

12375S Reducer

Batch: 1112704

09-10-06

150

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

09/10/07

Work Order ID 48670C

Page 3

Friday, June 26, 2009 9:20:49 AM

Item ID: D412-694-03

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Door Assembly

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	✓ COMPOSITE ASSEMBLY	0.00							
Small Fab	Memo	0.00							
Small Fab	D412-694-03 Assembly Process □ 1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF). □ 2- Install D3111-041 Plate Assembly. If needed, install temporary D3110-3								
170 	✓ QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Install door on mock up helicopter to insure proper fit and function.								
180 	✓ Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	(Put red label inside before putting the cover D3119-041/or Vip trim) □ 1- Install D3119-041 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly.								

091007
85 09-1007

09/10/07

09/1007

Work Order ID 48670C

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Item ID: D412-694-03

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Door Assembly

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

18 09 10 07

200

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

48670 W

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09 10 07 07

W 09.10.07

Picklist Print

Page 1

Friday, June 26, 2009 9:20:48 AM

Work Order ID: 48670C

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ NAS43DD3-40 		Purchased	No			130	Each	0.0000	2.0000			
Spacer												
✓ 80-005-2-8 		Purchased	No			160	Each	0.0000	21.0000			
Insert												
✓ ALS4-632-80 		Purchased	No			160	Each	0.0000	10.0000			
Insert												
✓ AN525-10R7 		Purchased	No			160	Each	0.0000	4.0000			
Screw												
✓ AN960JD10 		Purchased	No			160	Each	0.0000	8.0000			
Washer												
✓ AN960JD10L 		Purchased	No			160	Each	0.0000	13.0000			
Washer												
✓ AN960JD10LL 		Purchased	No			160	Each	0.0000	29.0000			
Washer												
✓ AN960JD6L 		Purchased	No			160	Each	0.0000	4.0000			
Washer												
✓ AN960JD8 		Purchased	No			160	Each	0.0000	2.0000			
Washer												

M11053 SP

~~M112439~~ 19443 SP

M17841 SP

M112314 SP

M112369 SP

M109632 SP

M19600 SP

M5519 SP

M111578 SP

9/9/17 QD

Picklist Print

Friday, June 26, 2009 9:20:48 AM

Work Order ID: 48670C

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN960JD8L 		Purchased	No			160	Each	0.0000	2.0000			
Washer ✓ BSP45 		Purchased	No			160	Each	0.0000	34.0000			
Commercial Rivet ✓ BSP46 		Purchased	No			160	Each	0.0000	12.0000			
Commercial rivet ✓ D3110-1RevC 		Manufactured	No			160	Each	0.0000	1.0000			
Escutcheon ✓ D3110-3RevC 		Manufactured	No			160	Each	0.0000	1.0000			
Handle ✓ D3111-041RevB 		Manufactured	No			160	Each	0.0000	1.0000			
Plate Assembly ✓ D3112-1RevB 		Manufactured	No			160	Each	0.0000	2.0000			
Guide ✓ D3113-1RevB 		Manufactured	No			160	Each	0.0000	1.0000			
Spring ✓ D3114-1RevB 		Manufactured	No			160	Each	0.0000	1.0000			
Pivot												

M 6956 SD

M 107296 SP

M 101237 SD

37757 SP

50041 SD

10536-77 SP

41644 SD

36725 SD

36726 SP

Picklist Print

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Work Order ID: 48670C

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3116-11RevA 		Manufactured	No			160	Each	0.0000	1.5000			
Seal										27241		
✓ D3116-5RevA 		Manufactured	No			160	f	0.0000	5.6700			
Seal										23699		
✓ D3119-041RevB 		Manufactured	No			160	Each	0.0000	1.0000			
Cover Assembly										27720 27724		
✓ D3120-1RevB 		Manufactured	No			160	Each	0.0000	1.0000			
Cover										350531		
✓ D3120-3RevB 		Manufactured	No			160	Each	0.0000	1.0000			
Cover										350315		
✓ D3125-1RevC 		Manufactured	No			160	Each	0.0000	1.0000			
Lever										10536-17		
✓ D3125-3RevC 		Manufactured	No			160	Each	0.0000	1.0000			
Lever										10536-17		
✓ D3125-5RevC 		Manufactured	No			160	Each	0.0000	1.0000			
Lever										10536-17		
✓ D3125-7RevC 		Manufactured	No			160	Each	0.0000	1.0000			
Lever										10536-17		

7/9/17

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Work Order ID: 48670C

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3129-1RevB 		Manufactured	No			160	Each	0.0000	2.0000			
Lever												
✓ D3130-1RevB 		Manufactured	No			160	Each	0.0000	2.0000			
Clevis Base												
✓ D3131-1RevB 		Manufactured	No			160	Each	0.0000	1.0000			
Stop												
✓ D3134-1RevE 		Manufactured	No			160	Each	0.0000	1.0000			
Rod												
✓ D3134-3RevE 		Manufactured	No			160	Each	0.0000	1.0000			
Rod												
✓ D3140-07RevF 		Manufactured	No			160	Each	0.0000	1.0000			
Door												
✓ D3143-1RevB 		Manufactured	No			160	Each	0.0000	1.0000			
Clevis												
✓ D3143-3RevB 		Manufactured	No			160	Each	0.0000	3.0000			
Clevis												
✓ D3144-105RevC 		Manufactured	No			160	Each	0.0000	1.0000			
Doubler												

M1053617 SP

M1053617 SP

M10536-17 SP

B50280 SP

52609 SP

48670C SP

M1053617 SP

M1053617 SP

B23143 SP

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Friday, June 26, 2009 9:20:48 AM

Work Order ID: 48670C

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3144-107RevC 		Manufactured	No			160	Each	0.0000	1.0000			B52616 AS
Doubler												
✓ D3144-1RevC 		Manufactured	No			160	Each	0.0000	1.0000			18816 SP
Doubler												
✓ D3145-1RevB 		Manufactured	No			160	Each	0.0000	1.0000			31733 SP
Bracket												
✓ D3146-1RevB 		Manufactured	No			160	Each	0.0000	1.0000			46927 SP
Bracket												
✓ D3147-1RevC 		Manufactured	No			160	Each	0.0000	2.0000			11930 SP
Pin												
✓ D3149-1RevB 		Manufactured	No			160	Each	0.0000	2.0000			10536-17 ET
Striker Plate												
✓ D3150-1RevB 		Manufactured	No			160	Each	0.0000	2.0000			M10536-17 SP
Guide												
✓ D3154-1RevB 		Manufactured	No			160	Each	0.0000	1.0000			M10536-17 SP
Key												
✓ D3157-1RevB 		Manufactured	No			160	Each	0.0000	2.0000			M10536-17 SP
Spacer												9/9/17 (12)

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Work Order ID: 48670C

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3159-041RevC Bracket Assembly		Manufactured	No			160	Each	0.0000	3.0000			SP
✓ D3159-043RevC Bracket Assembly		Manufactured	No			160	Each	0.0000	1.0000			SP
✓ FW10-032 Washer		Purchased	No			160	Each	0.0000	16.0000			SP
✓ FW4-032 Washer		Purchased	No			160	Each	0.0000	6.0000			SP
✓ M7885/3-4-4 Rivets		Purchased	No			160	Each	0.0000	2.0000			SP
✓ M7885/3-4-5 Rivet		Purchased	No			160	Each	0.0000	1.0000			SP
✓ MS20392-1C11 Pin		Purchased	No			160	Each	0.0000	2.0000			SP
✓ MS20392-2C11 Pin		Purchased	No			160	Each	0.0000	2.0000			SP
✓ MS20392-2C15 Pin		Purchased	No			160	Each	0.0000	7.0000			SP

M10536-M
50391

M11822 50

M11822 50

M104625 SP

M106167 SP

M18822 SP

M14149 SP

M101340 SP

9/9/17 Q

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Friday, June 26, 2009 9:20:48 AM

Work Order ID: 48670C

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MS21042L06 		Purchased	No			160	Each	0.0000	2.0000			
Nut												
✓ MS21042L3 		Purchased	No			160	Each	0.0000	7.0000			
Nut												
✓ MS24665-151 		Purchased	No			160	Each	0.0000	11.0000			
Cotter Pin												
✓ MS24694-C4 		Purchased	No			160	Each	0.0000	2.0000			
SCREW												
✓ MS24694-S53 		Purchased	No			160	Each	0.0000	2.0000			
SCREW												
✓ MS24694-S56 		Purchased	No			160	Each	0.0000	4.0000			
SCREW												
✓ MS24694-S60 		Purchased	No			160	Each	0.0000	4.0000			
Screw												
✓ MS25281-R6 		Purchased	No			160	Each	0.0000	2.0000			
Clamp												
✓ MS27039-1-06 		Purchased	No			160	Each	0.0000	12.0000			
Screw												

M112243 SP

M111274 SP

M14526 SP

M15924 SP

M15798 SP

M104407 SP

M104407 SP

M19098 SP

(2) (5)
M106815 M104289 SP

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Picklist Print

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Friday, June 26, 2009 9:20:48 AM

Work Order ID: 48670C

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly








Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MS27039-1-08 		Purchased	No			160	Each	0.0000	6.0000			
Screw												
✓ MS35206-231 		Purchased	No			160	Each	0.0000	2.0000			
Screw												
✓ MS35650-305T 		Purchased	No			160	Each	0.0000	4.0000			
Nut												
✓ MS51859-7 		Purchased	No			160	Each	0.0000	3.0000			
Washer												
✓ NAS1169-10L 		Purchased	No			160	Each	0.0000	4.0000			
Washer												
✓ NAS388-6-8P 		Purchased	No *			160	Each	0.0000	15.0000			
Screw												
✓ NAS391B6P 		Purchased	No			160	Each	0.0000	16.0000			
Washer												

M110552 SP

M11735 SD

M11786 SD

M11193 SD

M11753 SP

M112768 SP

M112195 SP

9/9/14 @

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Shop Packet Print

Page 8

Date: Monday, 22/06/2009 11:53:37 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOOR ASSEMBLY
Job Number :	48670C		
Estimate Number :	12353		
P.O. Number :		Part Number :	D41269403
This Issue :	22/06/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D412-694
First Issue :	22/06/2009	Project Number :	N/A
Previous Run :	39169C	Drawing Revision :	C1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	10/09/2009
Written By :			Qty: 1 Um: Each
Checked & Approved By :			
Comment :	Est Rev: A 05.12.09 New Issue KJ/RF Est Rev: B 06.04.18 New dwg rev. ecn781 EC Est Rev: C 06.07.11 Revised per B24660 KJ Est Rev:D 08-08-27 replace QC5 to QC14 seq.7 DD verified by:EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 ✓ DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Issue red decal labels for D412-694-03. CHG005

2.0 ✓ PG

PURCHASING



Comment: PURCHASING

 ISSUE P.O. 9004 1 X D3140-07 REV.F
 DELASTEK

C 20/09/2012 23 ①

3.0 ✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

 RECEIVE AND INSPECT FOR TRANSIT DAMAGE
 ENSURE MATERIAL CERT AND PROCESS SHEET ATTACHED

4.0 ✓ QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 ✓ D314007

Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Door Kit
 Batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:53:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-03 Drill Process

1- Drill pilot holes Ø(#30) using drill Jig D3144-T4 for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T5/-T6 as per Dwg D412-694 page 3. Note: Ensure slot is aligned with mark for reference.

2- Drill Pilot holes Ø(#30) using drill Jig D3120-3T1 for bottom cover. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3.

3- Drill Pilot holes Ø(#30) using drill Jig DT8703-4 for hinges, top cover and D3131-1 spring. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3 & 4 (view MM-MM).

4- Drill Pilot holes Ø(#1/8") for clevis base and stop at top of the door using drill Jig DT8703-5. Open (1) hole Ø(#10) 0.193 for clevis base and (2) holes Ø(#19) 0.166 for stop as per Dwg D412-694 page 5 (section FF-FF.)

5- Drill Pilot hole Ø(#1/8") for clevis base at bottom of the door using drill Jig DT8703-6. Open hole Ø(#10) 0.193 for clevis base as per Dwg D412-694 page 5 (section FF-FF).

6- Ensure 17 1/16" from opposite edge of the door for Ø5/8" hole is in proper location top and bottom.

7- Drill through only (1) hole Ø(5/8") and pilot drill (2) holes Ø(#30) for insert. Open (2) holes to 37/64" (0.578) for clevis inserts as per Dwg D412-694 page 5 (section AA-AA).

7.0



8000528

Insert



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Insert

Batch

A/R Hysol EA934NA

Expiry Date:

8.0



COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM).

2- Sand flush excess Hysol around the insert on both doors.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:53:37 AM
Usér: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

10.0

✓ COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1. Apply Primer filler and reducer around the inserts on both doors.

A/R 11045 Primer Filler

Batch: _____

A/R 12375S Reducer

Batch: _____

11.0

✓ QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

12.0

✓ D31101

Escutcheon



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Escutcheon

Batch _____

13.0

✓ D31103

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch _____

14.0

✓ D3111041

Plate Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Plate Assembly

Batch _____

15.0

✓ D31121

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guide

Batch _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:53:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

✓ D31131

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spring

Batch

17.0

✓ D31141

Pivot



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pivot

Batch

18.0

✓ D31165

Seal



Comment: Qty.: 5.6700 f(s)/Unit Total : 5.6700 f(s)

Seal 110-031-4

Batch

19.0

✓ D311611

Seal



Comment: Qty.: 1.5000 f(s)/Unit Total : 1.5000 f(s)

SEAL

Batch

20.0

✓ D3119041

Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover Assembly

Batch

21.0

✓ D31201

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover, Flat Pattern

Batch

22.0

✓ D31203

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:53:37 AM
Usér: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

✓ D31251

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

D3125-1 Lever

Batch

24.0

✓ D31253

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

25.0

✓ D31255

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

26.0

✓ D31257

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

27.0

✓ D31291

Lever



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Lever

Batch

28.0

✓ D31301

Clevis Base



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis Base

Batch

29.0

✓ D31311

Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Stop

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:53:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

30.0	✓ D31341	Rod
------	----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod

Batch

31.0	✓ D31343	Rod
------	----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

D3125-3 Rod

Batch

32.0	✓ D31431	Clevis
------	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clevis

Batch

33.0	✓ D31433	Clevis
------	----------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Clevis

Batch

34.0	✓ D31441	Doubler
------	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

35.0	✓ D3144105	Doubler
------	------------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

36.0	✓ D3144107	Doubler
------	------------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:53:37 AM
Usèr: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0



D31451

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

38.0



D31461

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

Batch

39.0



D31471

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

40.0



D31491

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate

Batch

41.0



D31501

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guide

Batch

42.0



D31541

Key



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Key

Batch

43.0



D31571

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:53:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

44.0	✓ D3159041	Bracket Assembly
------	------------	------------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Bracket Assembly

Batch

45.0	✓ D3159043	Bracket Assembly
------	------------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly

Batch

46.0	✓ AN52510R7	Screw
------	-------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

Batch

47.0	✓ AN960JD6L	Washer
------	-------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer

Batch

48.0	✓ AN960JD8	Washer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer

Batch

49.0	✓ AN960JD8L	Washer
------	-------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer

Batch

50.0	✓ AN960JD10	Washer
------	-------------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:53:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

51.0	✓ AN960JD10L	Washer
------	--------------	--------



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

Batch

52.0	✓ AN960JD10LL	Washer
------	---------------	--------



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Washer

Batch

53.0	✓ ALS463280	Insert
------	-------------	--------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Insert

Batch

54.0	✓ BSP45	Commercial Rivet
------	---------	------------------



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Commercial Rivet

Batch

55.0	✓ BSP46	Commercial rivet
------	---------	------------------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Commercial rivet

Batch

56.0	✓ FW4032	Washer
------	----------	--------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

57.0	✓ FW10032	Washer
------	-----------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:53:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

58.0

✓ M7885344

Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rivets

Batch

59.0

✓ M7885345

Rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rivet

Batch

60.0

✓ MS203921C11

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

61.0

✓ MS203922C11

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

62.0

✓ MS203922C15

Pin



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pin

Batch

63.0

✓ MS21042L3

Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Nut

Batch

64.0

✓ MS21042L06

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:53:38 AM
Usér: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

65.0

✓ MS24665151

Cotter Pin



Comment: Qty.: 11.0000 Each(s)/Unit Total : 11.0000 Each(s)

Cotter Pin

Batch

66.0

✓ MS24694C4

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

67.0

✓ MS24694S53

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

68.0

✓ MS24694S56

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

Batch

69.0

✓ MS24694S60

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

70.0

✓ MS25281R6

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

Batch

71.0

✓ MS27039106

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:53:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

72.0

✓ MS27039108

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch

73.0

✓ MS35206231

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

74.0

✓ MS35650305T

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch

75.0

✓ MS518597

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch

76.0

✓ NAS116910L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch

77.0

✓ NAS38868P

Screw



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Screw

Batch

78.0

✓ NAS391B6P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:53:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

79.0

✓ NAS43DD340

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

80.0

✓ COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-03 Assembly Process

1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

2- Install D3111-041 Plate Assembly. If needed, install temporary D3110-3 Handle as per Dwg D412-694 page 5 (view W and section BB-BB). Note: Adjust D3111-041 high with washer as required. Check that the D3154-1 key doesn't touch the base of the door.

3- Assemble Rod as per Dwg D412-694 page 5 (view W)

4- Assemble D3147-1 Pin to the lever as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

5- Connect Rods and D3111-041 Plate Assembly as per Dwg D412-694 page 5 (view W).

6- Install D3111-041 and mechanism in place. Use D3110-3 Handle to make lock and mechanism of the rod work properly. Mark the center NAS1169-10L washer into the door and drill (#10) Ø0.193". C'sink Ø0.385 x 100° from far side of the door. Ensure D3111-041 is level with inside door surface as per Dwg D412-694 page 5 (view W).

7- Install (1) D3159-041 bracket assembly to side of the window. Transfer hole from the door to D3159-041 bracket. Drill Ø(#30) C'sink for the rivet (note: use 1" pitch holes) as per Dwg D412-694 page 5 (view W) and (section LL-LL).

8- Drill (#19), C'sink Ø0.332 x 100°. Install MS25281-R6 Clamp as per Dwg D412-694 page 5 (view W). Ensure Rod moves freely when installing clamps.

9- Install (1) D3159-043 bracket assembly. Transfer (2) holes from the door to the bracket. Install (1) M7885/3-4-5 rivet and install the second rivet with the doubler.

Note: Layout properly as per Dwg D412-694 page 5 (view W). Note: Second hole will be done with doubler and seal.

10- Drill (4) (#10) Ø0.193" holes from D3150-1 guide by laying out doublers with temporary seal segment with strike plate. Check location of strike plate by laying out small and large door together.

Note: Position strike plate when big door is in locked position.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

11- Open (#30) pilot hole to Ø"G" (0.261) in the door for ALS4-632-80 insert. Install insert as per Dwg D412-694 page 3.

12- Install Doublers and D3159-041 bracket. Cut slot openings from the door to D3116-5-0680 Seal as per Dwg D412-694 page 3 (section JJ-JJ)

13- Install D3150-1 Guide top/bottom as per Dwg D412-694 page 5 (view DD & CC).

14- Install Hinge Bracket and D3113-1 Spring as per Dwg D412-694 page 3 & 4 (view MM-MM).

15- Install top/bottom Covers. Attach D3116-11-0180 Seal as per Dwg D412-694 page 3.

A/R RTV732 Clear Batch: _____ Expiry Date: _____

FOR D412-694-011 ONLY

16- Drill Pilot holes Ø(#1/8") for D3119-041 cover using drilling Jig D3119-041T1/T2 as per Dwg D412-694 page 3. Trim D3119-041 Cover Assembly and transfer Ø(#30) holes using hole finder tool from the door to the cover. Open holes to Ø5/32" (0.156).

81.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

82.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

(Put red label inside before putting the cover D3119-041/or Vip trim)

1- Install D3119-041 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly.

83.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

84.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:53:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

85.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO '106'	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED
06.11.13 [Signature]

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

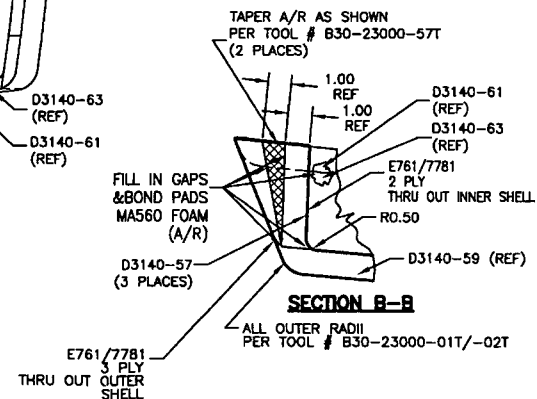
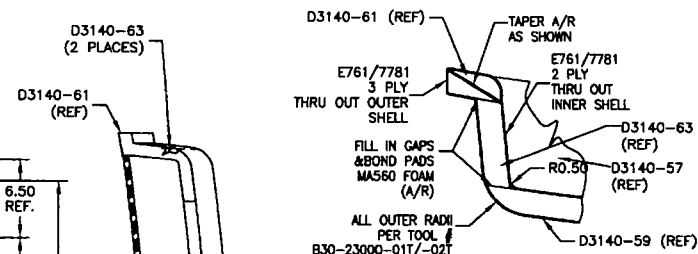
14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1

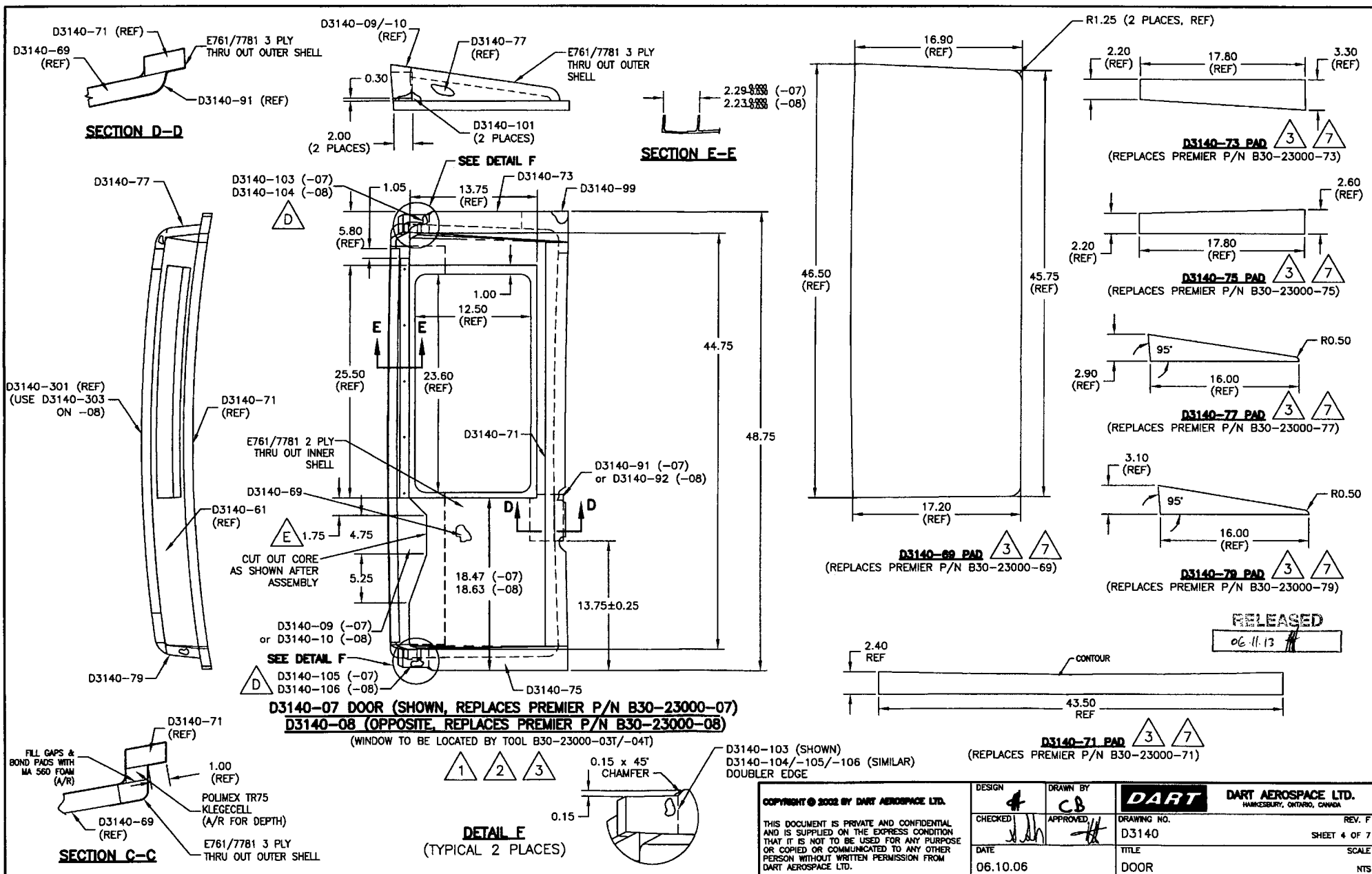
F

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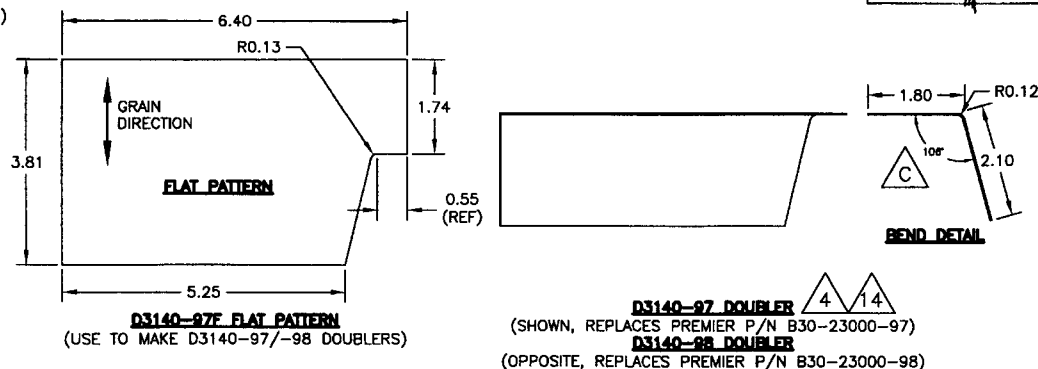
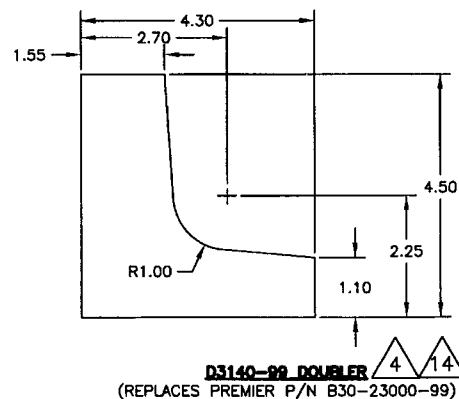
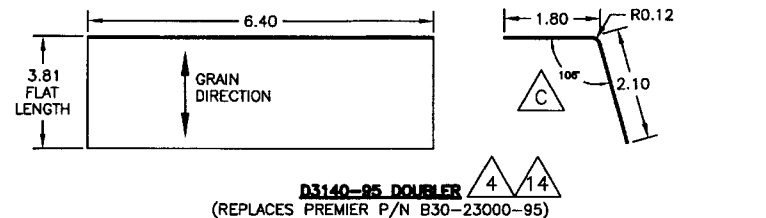
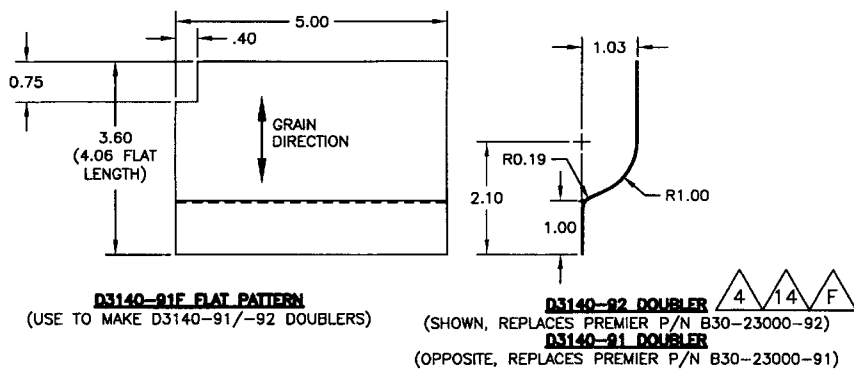
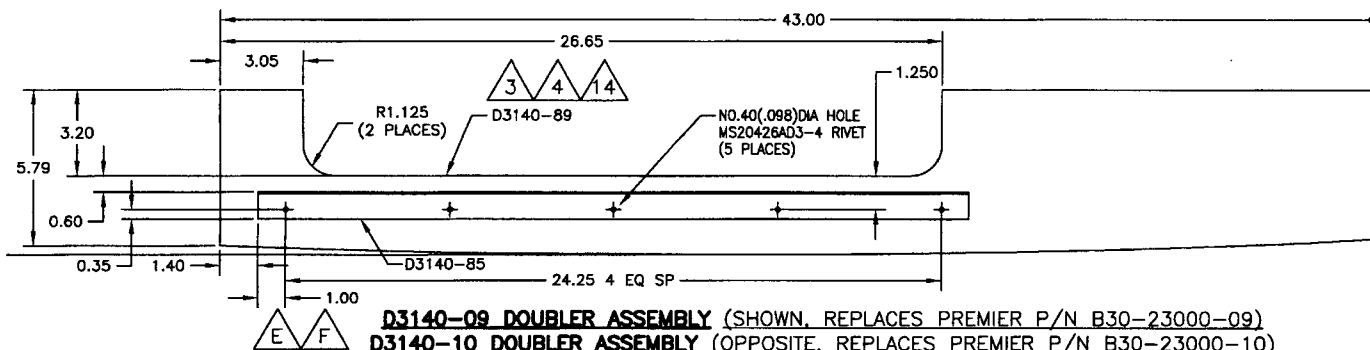
NTS



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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. F
DATE	TITLE	D3140	SHEET 4 OF 7
06.10.06	DOOR		SCALE NTS



RELEASED

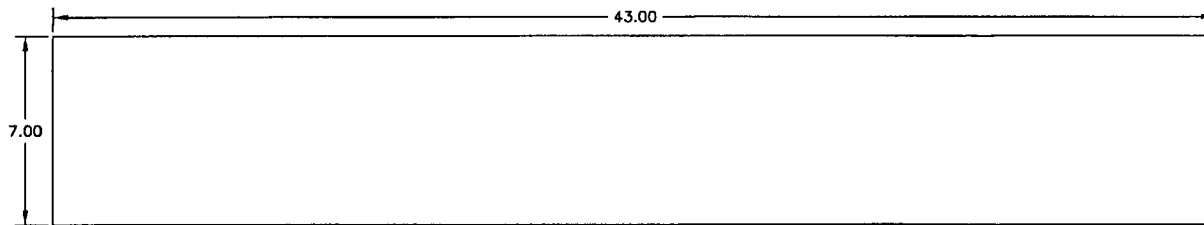
06.11.13

BEND DETAIL

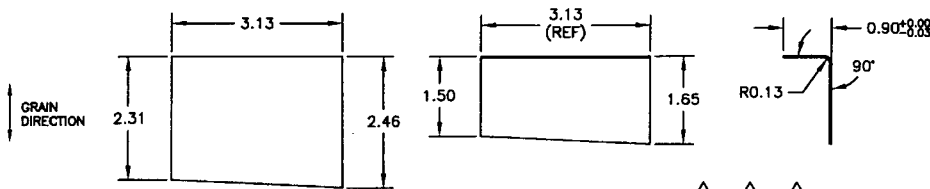
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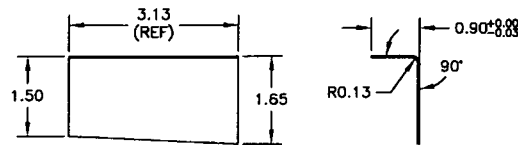
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CHECKED JH	APPROVED JH	DRAWING NO. D3140	REV. F SHEET 5 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	



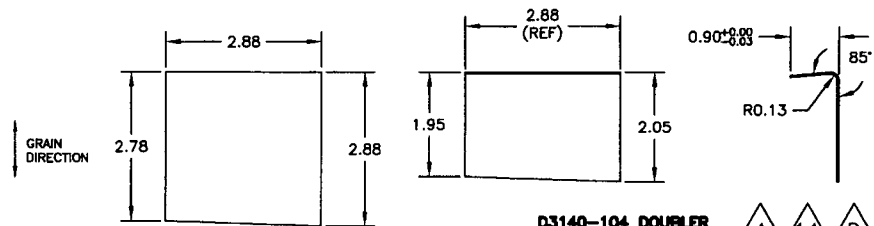
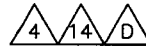
D3140-87 DOUBLER
(REPLACES PREMIER P/N B30-23000-87)



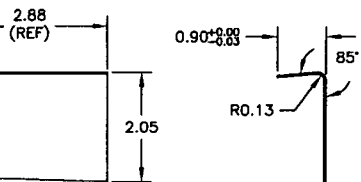
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



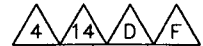
D3140-105 DOUBLER
D3140-106 OPPOSITE



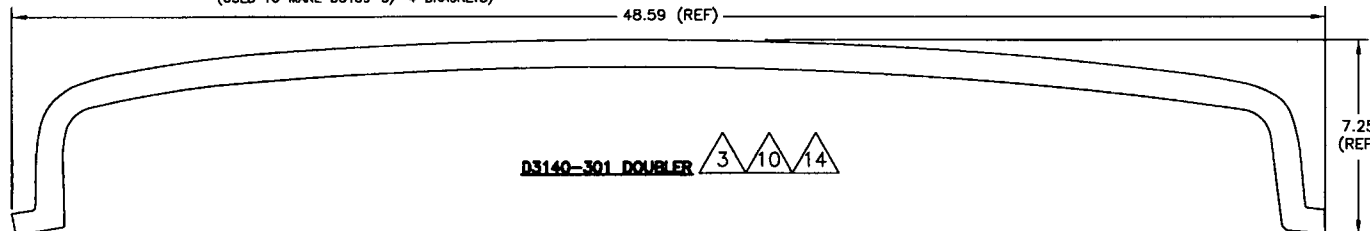
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



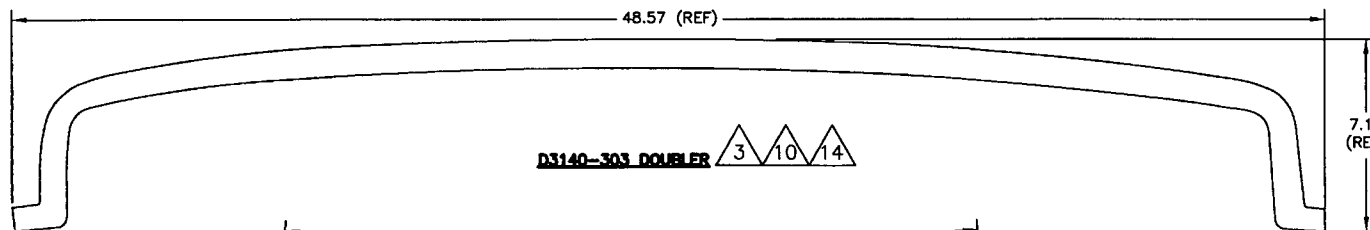
D3140-104 DOUBLER
D3140-103 OPPOSITE



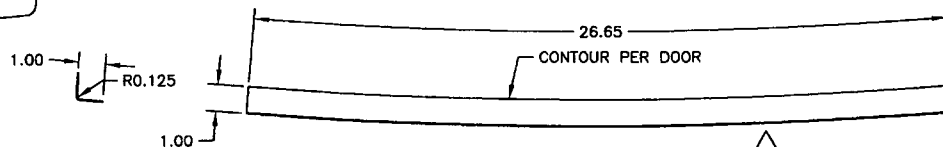
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER



D3140-303 DOUBLER

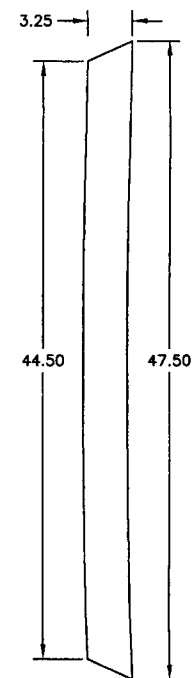
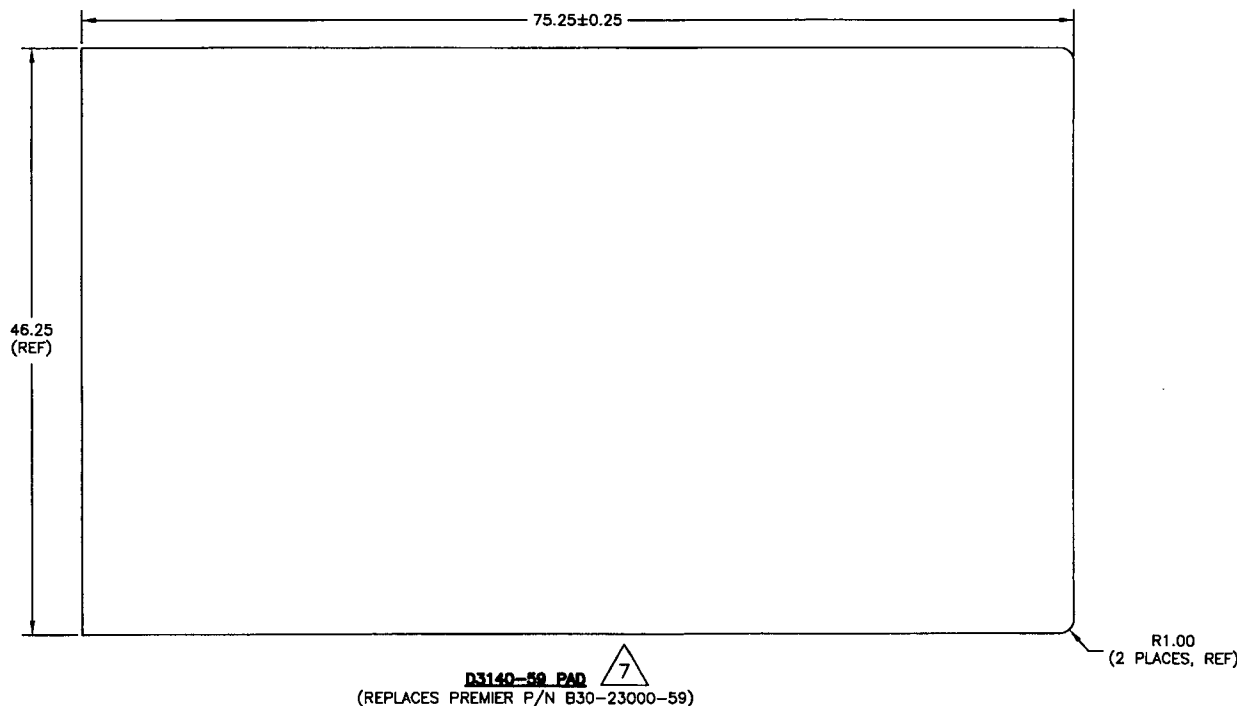
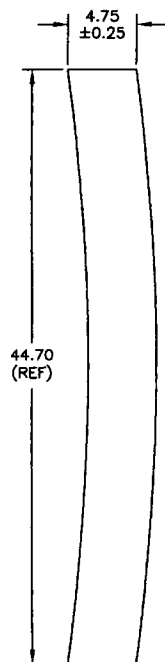
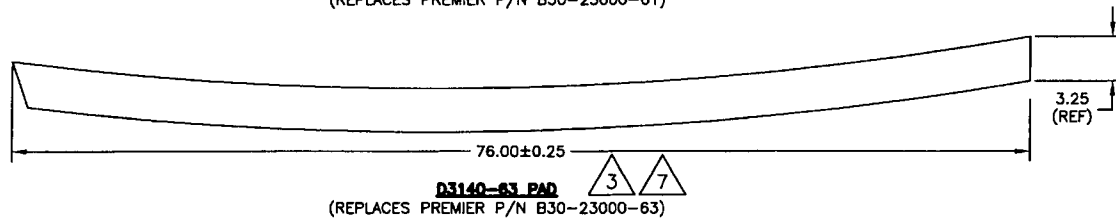
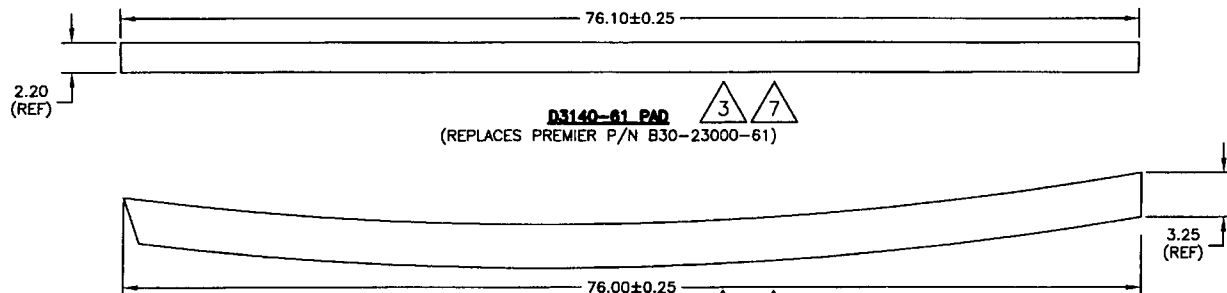


D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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06.11.13

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CHECKED	APPROVED	DRAWING NO. D3140		REV. F SHEET 6 OF 7	
DATE 06.10.06		TITLE DOOR		SCALE NTS	



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06.11.13

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DESIGN 4	DRAWN BY C.B.	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3140
DATE 06.10.06	TITLE DOOR	REV. F SHEET 7 OF 7 SCALE NTS

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D412-694-01	DOOR ASSEMBLY
	X			D412-694-02	DOOR ASSEMBLY
		X		D412-694-03	DOOR ASSEMBLY
			X	D412-694-04	DOOR ASSEMBLY
		1	1	D3110-1	ESCUTO-EON
		1	1	D3110-3	HANDLE
1	1			D3110-5	HANDLE ASSEMBLY
		1	1	D3111-041	PLATE ASSEMBLY
		2	2	D3112-1	GUIDE
		1	1	D3113-1	SPRING
		1	1	D3114-1	PIVOT
1	1			D3115-1	BRACKET
		1	1	D3116-11-0180	SEAL
		1	1	D3116-5-0280	SEAL
1	1			D3116-7-0280	SEAL
1	1			D3116-9-0770	SEAL
		1		D3119-041	COVER ASSEMBLY
		1		D3119-042	COVER ASSEMBLY
		1		D3120-1	COVER
		1		D3120-2	COVER
		1		D3120-3	COVER
		1		D3120-4	COVER
3	3			D3121-041	BRACKET ASSEMBLY (ROLLER)
1	1			D3121-043	BRACKET ASSEMBLY (ROLLER)
		1		D3121-044	BRACKET ASSEMBLY (ROLLER)
1	1			D3122-1	LEVER
2	2			D3123-1	CAM
1	1			D3124-1	HOCK
1	1			D3124-2	HOCK
		1	1	D3125-1	LEVER
		1	1	D3125-3	LEVER
		1	1	D3125-5	LEVER
		1	1	D3125-7	LEVER
1	1			D3126-1	BRACKET (SLIDER)
1	1			D3126-3	BRACKET (SLIDER)
5	5			D3126-5	BRACKET (SLIDER)
1	1			D3127-1	SPACER
		1	1	D3128-1	SHIM
		2	2	D3129-1	LEVER
		2	2	D3130-1	CLEVIS BASE
		1	1	D3131-1	STOP
1	1			D3132-041	ROD WELDMENT
		1		D3132-042	ROD WELDMENT
		1		D3133-041	ROD WELDMENT
1	1			D3133-042	ROD WELDMENT
		1	1	D3134-1	ROD
		1	1	D3134-3	ROD
1	1			D3135-041	HANDLE WELDMENT
1	1			D3137-045	BRACKET ASSEMBLY
1	1			D3138-1	COVER
1	1			D3138-2	COVER
1	1			D3139-1	GUARD
1	1			D3139-3	GUARD
1	1			D3139-4	GUARD
1	1			D3140-05	DOOR
		1		D3140-06	DOOR
		1		D3140-07	DOOR
		1		D3140-08	DOOR
2	2			D3141-1	SPRING
		1	1	D3143-1	CLEVIS
		3	3	D3143-3	CLEVIS
		1		D3144-1	DOUBLER
1	1			D3144-3	DOUBLER
		1		D3144-105	DOUBLER
		1		D3144-107	DOUBLER
1	1			D3144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D3144-111	DOUBLER
	1			D3144-115	DOUBLER
		1		D3144-117	DOUBLER
		1		D3144-121	DOUBLER
		1		D3144-119	DOUBLER
		1		D3144-123	DOUBLER
1	1			D3144-13	DOUBLER
		1		D3145-1	HINGE BRACKET
		1		D3145-2	HINGE BRACKET
		1		D3146-1	HINGE BRACKET
		1		D3146-2	HINGE BRACKET
		2	2	D3147-1	FIN
2	2			D3148-1	CLEVIS
		2	2	D3148-1	STRIKER PLATE
		2	2	D3150-1	GUIDE
1	1			D3151-041	DOUBLER ASSEMBLY
1	1			D3152-041	BRACKET ASSEMBLY
		1		D3152-042	BRACKET ASSEMBLY
		1	1	D3154-1	KEY
1	1			D3155-041	BRACKET ASSEMBLY
1	1			D3155-042	BRACKET ASSEMBLY
2	2			D3156-1	BRACKET
		2	2	D3157-1	SPACER
		3	3	D3159-041	BRACKET ASSEMBLY
		1		D3159-043	BRACKET ASSEMBLY
		1		D3159-044	BRACKET ASSEMBLY
10	10			D3162-041	BRACKET ASSEMBLY
1	1			D3162-043	BRACKET ASSEMBLY
1	1			D3162-044	BRACKET ASSEMBLY
1	1			D3163-041	COVER ASSEMBLY
		1		D3163-042	COVER ASSEMBLY
1	1			D3183-041	BRACKET ASSEMBLY (ROLLER)
		1		D3183-042	BRACKET ASSEMBLY (ROLLER)
1	1			D3203-1	HANDLE ASSEMBLY
2	2			D3308-1	DOUBLER
55	55	21	21	80-005-2-8	INSERT (OR SL2052-3-4)
10	10			AN625-10F6	SCREW
8	8	4	4	AN625-10F7	SCREW
		8	8	AN680D10	WASHER
18	18	4	4	AN680D10L	WASHER
13	13	32	32	AN680D10LL	WASHER
6	6			AN680D10L	WASHER
		4	4	AN680D10L	WASHER
6	6			AN680D10L	WASHER
		2	2	AN680D10L	WASHER
		2	2	AN680D10L	WASHER
		10	10	ASL4-632-80	INSERT
87	87	50	50	BSF45	RIVET
		12	12	FW10-032	WASHER
		6	6	FW10-032	WASHER
12	12			M7885-24	RIVET (OR CR3213-4-3)
		3	3	M7885-24	RIVET (OR CR3212-4-3)
		2	2	MS20392-1C11	FIN
2	2			MS20392-2C15	FIN
2	2	2	2	MS20392-2C17	FIN
2	2			MS20392-2C9	FIN
2	2			MS20392-3C21	FIN
8	8			MS20426AD3	RIVET
12	12			M7885/3-4	Rivet
8	8			MS20426AD4	Rivet

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
20	20			MS20426AD4	RIVET
		6	6	MS21042L05	NUT
6	6	2	2	MS21042L08	NUT
		5	5	MS21042L3	NUT
4	4			MS21042L4	NUT
4	4			MS21072L3	NUT/PLATE
6	6	9	9	MS24665-151	COTTER PIN
4	4			MS24665-S271	SCREW
		2	2	MS24664-C4	SCREW
4	4			MS24664-C5	SCREW
6	6			MS24664-S5	SCREW
18	18			MS24664-S50	SCREW
		4	4	MS24664-S55	SCREW
		2	2	MS24664-S53	SCREW
		4	4	MS24664-S50	SCREW
4	4			MS24664-S58	SCREW
		2	2	MS25281-F8	CLAMP
2	2	2	2	MS27039-1-05	SCREW
14	14	12	12	MS27039-1-05	SCREW
13	13	6	6	MS27039-1-08	SCREW
		2	2	MS35205-231	SCREW
2	2			MS35275-233	SCREW
2	2			MS35645-264	NUT
		4	4	MS35650-305T	NUT
2	2			MS35650-3252	NUT
2	2	3	3	MS51865-7	WASHER
		4	4	NAS1165-10L	WASHER
		14	14	NAS386-6-8P	SCREW
		15	15	NAS38188P	WASHER
7	7			NAS3000-10	SPACER
6	6			NAS3000-14	SPACER
		2	2	NAS3000-40	SPACER

GENERAL NOTES

- FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D3124-1/2 HOOK RESTS AGAINST CUTOUT SHOWN IN VIEW N.
- IF REQUIRED, NOTCH D3125-1 LEVER (REF) TO CLEAR THE D3130-1 CLEVIS BASE (REF. 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- HOLES AND PARTS TO BE LOCATED PER DRILLING JIGS. B30-23000-01; D3144-TU-T2-T3; D78703-3; D3162-041T1 (FOR -01 DOOR ASSY); B30-23000-02; D3144-T7-T8-T9; D78703-9; D3162-041T2 (FOR -02 DOOR ASSY); D3144-T4-T5-T6; D3119-041T1; D3112-TU-T2 (FOR -03 DOOR ASSY); D3144-T10-T11-T12; D3119-042T1; D3112-TU-T2 (FOR -04 DOOR ASSY).
- INSTALL INSERTS PER DART Q3 005. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.
- TOLERANCES ARE PER DART Q3 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES.
- IDENTIFY D412-694-01-02-03-04 DOOR ASSEMBLIES USING D2729-1 DECALS.

C1	06.03.28	ADD OPTION M7885/3-4
C	05.11.23	ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES
B	04.10.07	UPDATE DRAWING
A	C2.05.21	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	#	APPROVED #
DATE	05.11.23	DRAWING NO. D412-694
		TITLE DOOR ASSEMBLY
		REV. C SHEET 1 OF 6 SCALE NTS

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102150

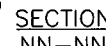


D412-694-01 DOOR ASSY (SHOWN)
D412-694-02 DOOR ASSY (OPP.)

VIEW LOOKING @ INSIDE OF DOOR



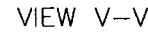
(D3138-1/-2 SHOWN IN SECTIONS
FOR CLARITY OF HDWR LOCATIONS)



D3144-13 DOUBLER (1)
BSP45 RIVETS (39 PLACES)
TRANSFER DRILL #30 FROM
DOUBLER TO DOOR
APPLY 732 RTV CLEAR (A/R) IN
RIVET HOLE PRIOR TO INSTALLATION
AND RIVET HEAD AFTER INSTALLATION



VIEW N
LOCATE SLOTS PER LOCATION
OF 03155-041/-042 BRKT SHOWN
IN VIEW P (2 PLACES)

**DART**

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DRAWING NO.

0412-694

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DATE _____

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HAWKESBURY, ONTARIO, CANADA

REV

SHEET 2 OF 2

SC

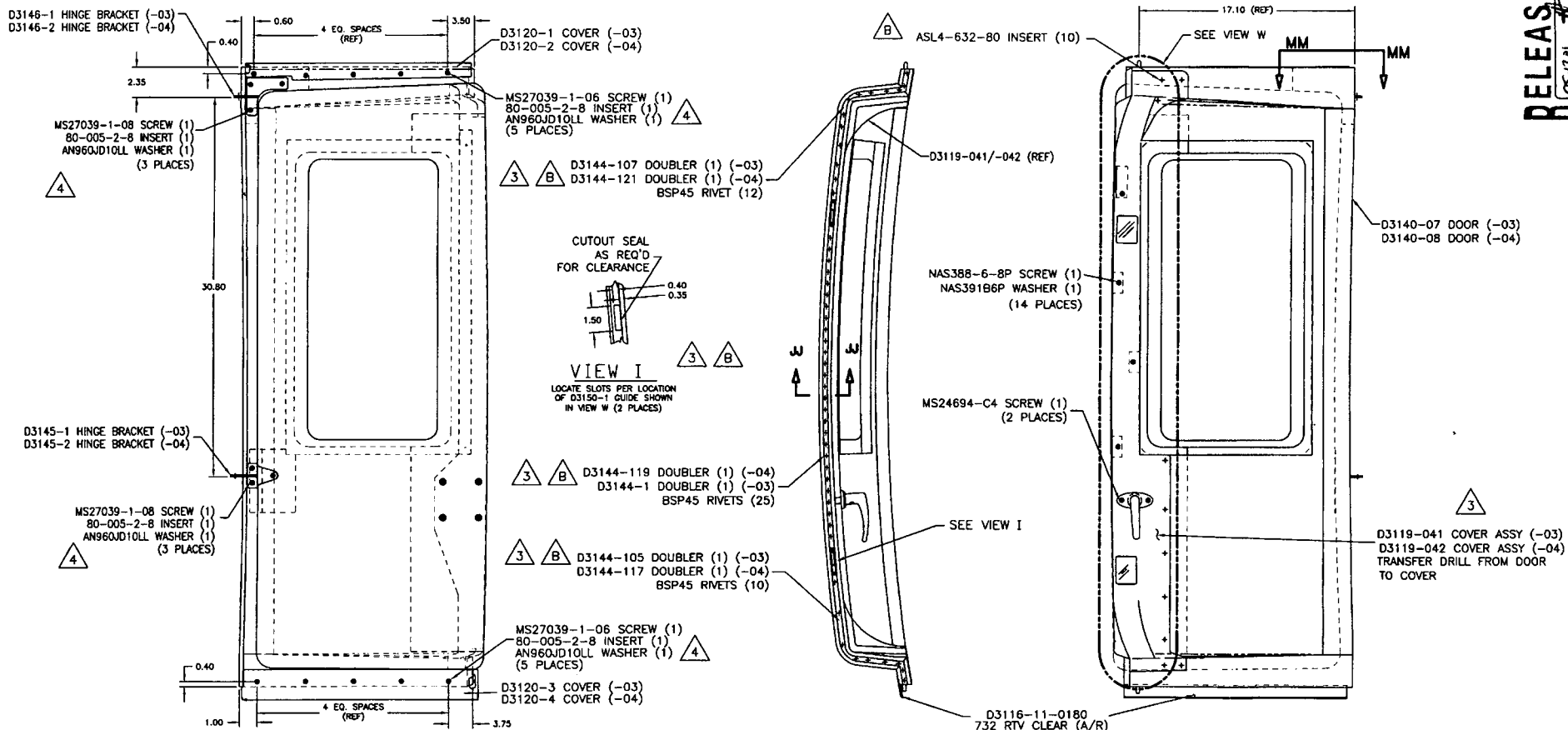
REV. C

SHEET 2 OF 6

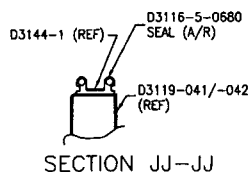
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SCALE
NFC

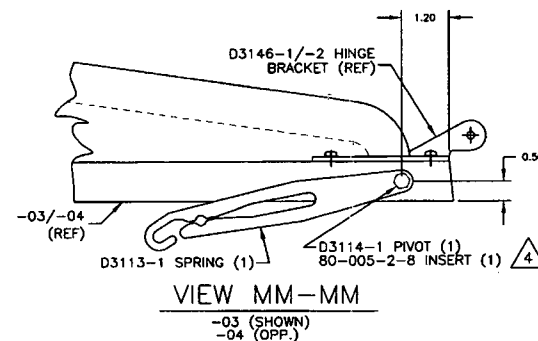
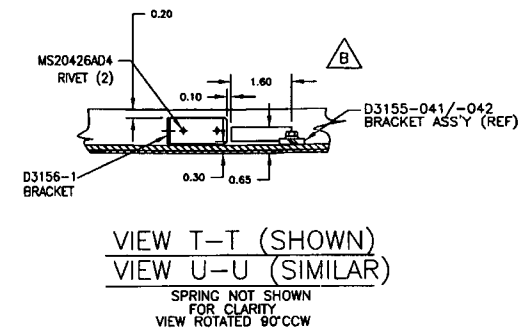
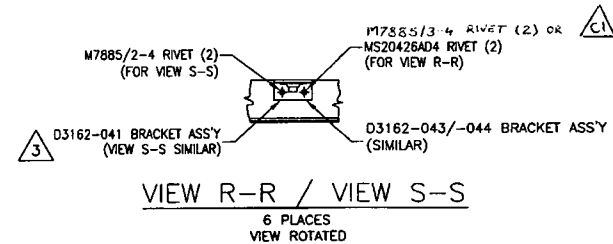
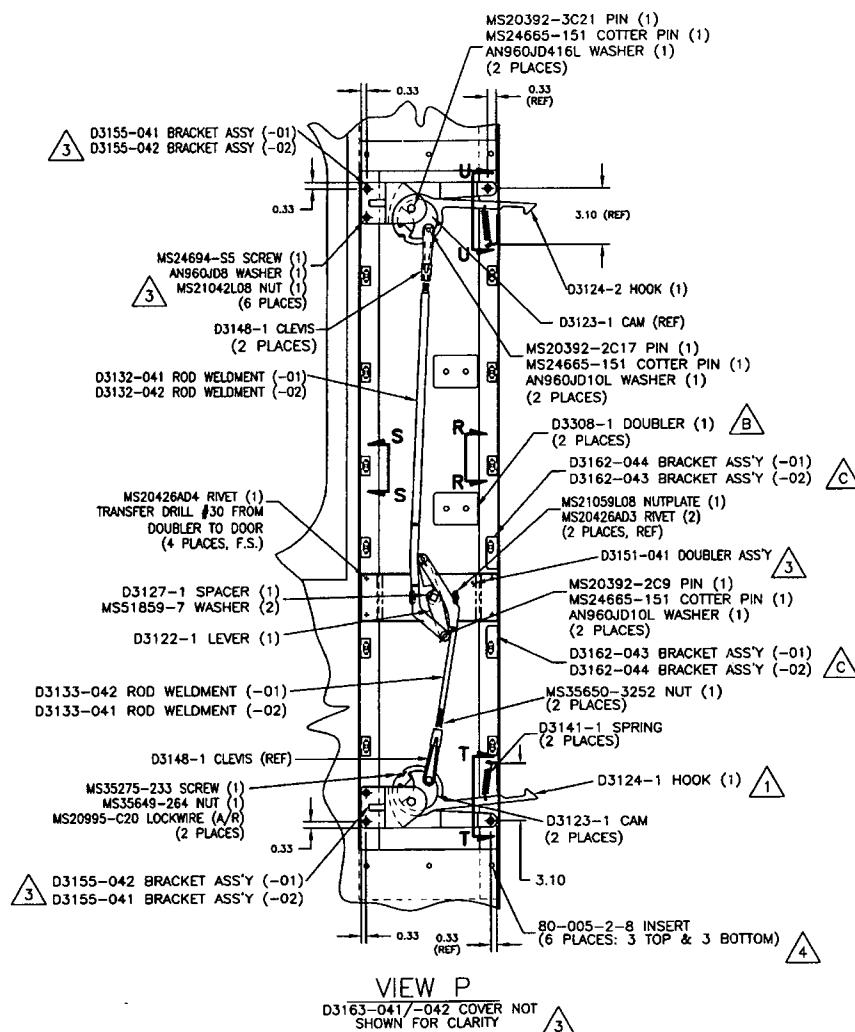
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D412-694-03 DOOR ASSY (SHOWN)
D412-694-04 DOOR ASSY (OPP)

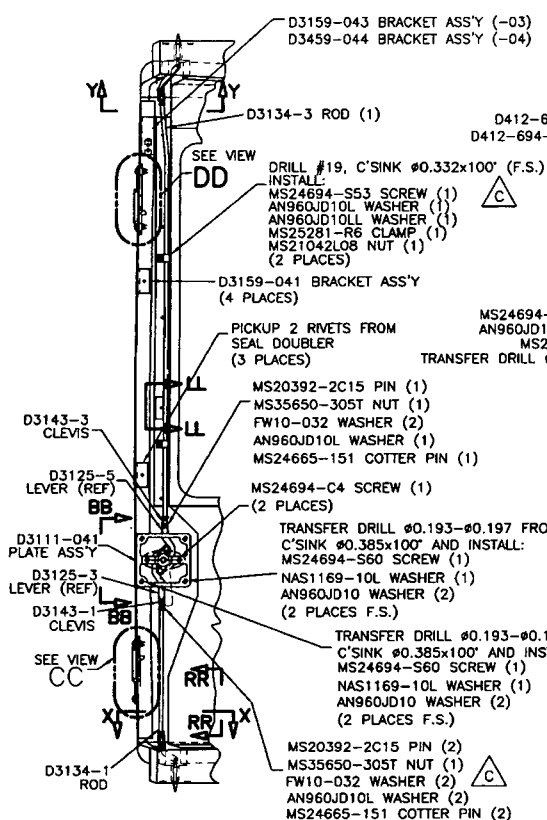


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DATE 05.11.23		TITLE DOOR ASSEMBLY		SCALE NTS	



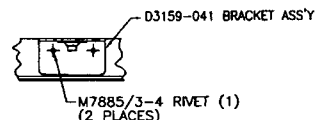
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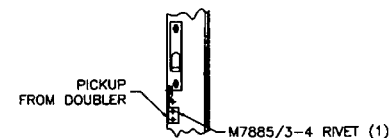


VIEW W

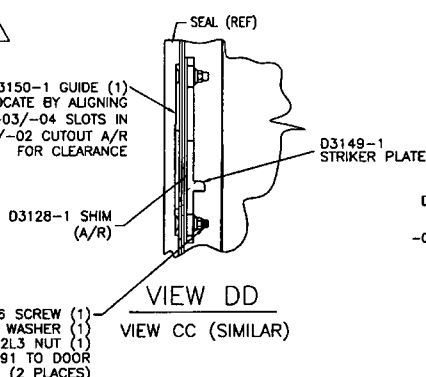
D3119-041/-042 COVER ASS'Y NOT SHOWN FOR CLARITY
SEAL ALSO NOT SHOWN FOR CLARITY



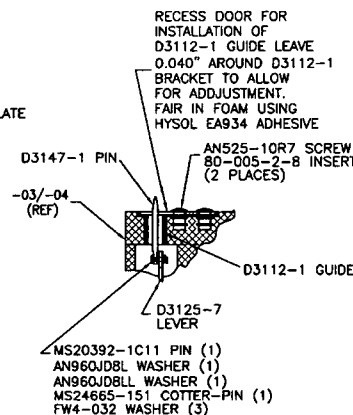
SECTION LL-LL (3 PLACES) VIEW ROTATED 90°CCW



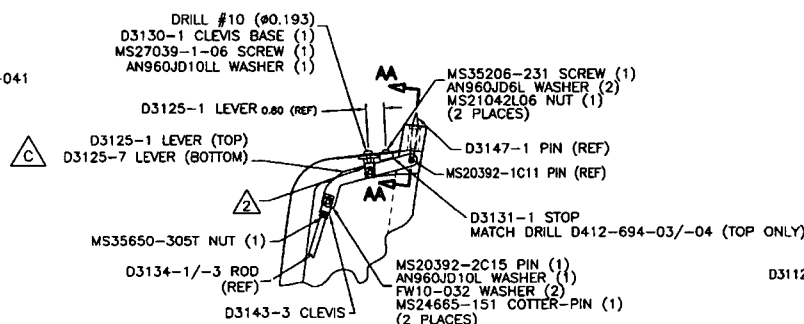
VIEW RR-RR



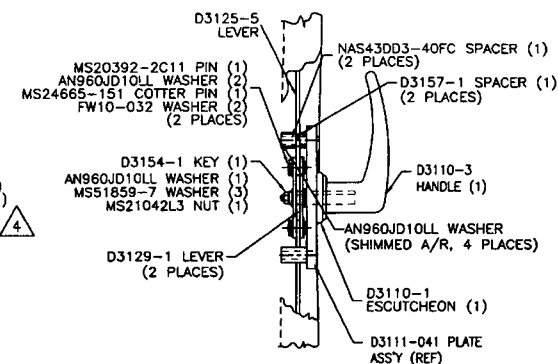
VIEW DD VIEW CC (SIMILAR)



SECTION AA-AA

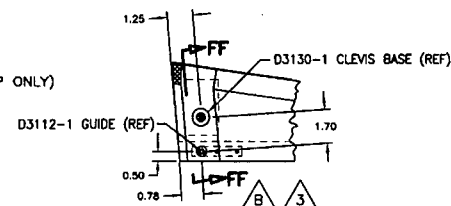


SECTION FF-FF



SECTION BB-BB

VIEW SHOWN WITH MECHANISM
IN THE UNLOCKED POSITION
FOR CLARITY



SECTION X-X (SHOWN) SECTION Y-Y (SIMILAR)

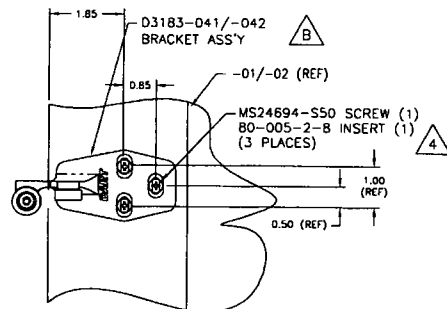
D3125-1 LEVER NOT SHOWN FOR CLARITY

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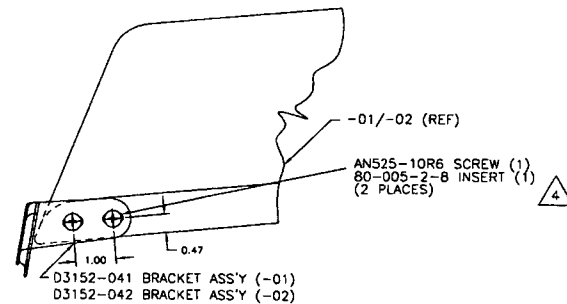
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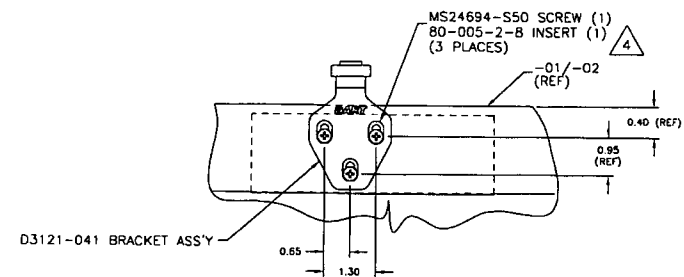
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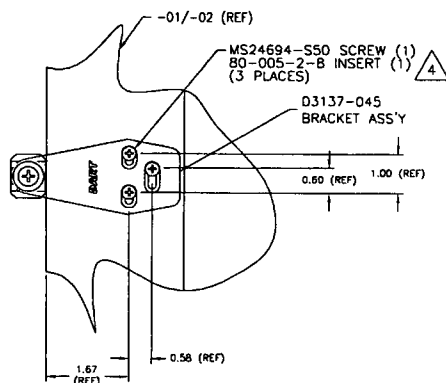
VIEW J



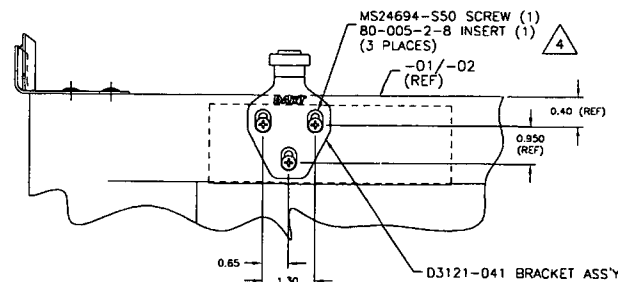
VIEW Q



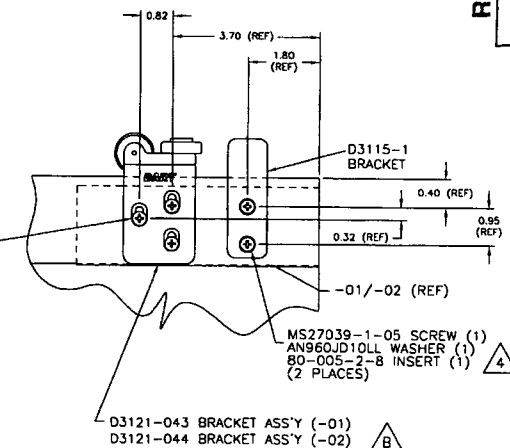
VIEW L



VIEW H



MS24694-S50 SCREW (1)
80-005-2-B INSERT (1)
(3 PLACES)



VIEW M

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